

Work Order ID 76383

76383

Page 1

November-11-11 9:23:13 AM

Item ID: D2989-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 11/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100 0.00
100 Large Fab
 Large Fab Memo 0.00
 Large Fab 1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989
 2- tack weld mesh on basket as per dwg D2989 using DT9445 jig
 ****cut cutouts with zip cut as per dwg D3832****
 3- remove from jig and weld lable plate as per dwg D2989
 A/R ER316 S.S. Rod Batch: 114649
 *** PLEASE NOTE****
 IF MAKING -043A :
 ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER
 DSI9473

Plin-12-22 1x

110 0.00
110 QC9- Inspect visual per QSI004- Fusion Welds
 QC Memo 0.00
 Quality Control

BE
11-12-22

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten signature: XCP M-L 11/12/28

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME: 9:00OVEN TEMPERATURE: 400 OFFINISH TIME: 9:30

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

11/12/28

131

Wing Walk as per dwg QSI005 4.4 Batch 119094 0.00***131***

HandFinish

Hand Finishing

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg

A/R Spray paint black batch: 11819*11-12-28*

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140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
141	Identify as per dwg & Stock Location: _____	0.00							
141	w/o 76371								
Packaging	Memo	0.00							
Packaging	D380-607-043								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

1 BL 12-1-4

OK 12/01/05

mk
12-01-04

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Picklist Print

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Page 1

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Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2221-1		Manufactured	No			100	Each	16.0000	2	2			
D2221-1									**				
Rib													

Location Loc Qty Loc Code

WA 16
 71372 4
 72297 12

D2506		Manufactured	No			100	Each	11.0000	1	1			
D2506									**				
Label Plate													

Location Loc Qty Loc Code

WA 11
 71087 1
 74142 10

D2512-7		Manufactured	No			100	Each	5.0000	1	1			
D2512-7									**				
Rib													

Location Loc Qty Loc Code

WA 4
 53444 0
 71220 4
 WA006 1
 67445 1

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Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

23.0000

2

2

D2581

Mounting Bracket

**

Pl 11.12.19

Location

Loc Qty

Loc Code

WA

23

69739

2

70766

2

73762

19

B75280 → (3)

D2989-13

Manufactured No

100

Each

8.0000

2

2

D2989-13

Rib

**

Pl 11.12.19

Location

Loc Qty

Loc Code

WA

8

71556

2

72410

6

(1)
(1)
2

D2989-19

Manufactured No

100

Each

8.0000

2

2

D2989-19

Rib

**

Pl 11.12.19

Location

Loc Qty

Loc Code

WA

8

71477

2

72411

6

(2)
1

D3832-3

Manufactured No

100

Each

3.0000

1

1

D3832-3

Mesh (Lid)

**

Pl 11.12.19

Location

Loc Qty

Loc Code

WA

3

71301

3

(1)

November-11-11 9:23:17 AM

Shop Packet Print

Page 2

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Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-3

Manufactured No

100 Each

17.0000

2

2

D3833-3

Mesh (Lid End)

**

Pl 11.12.19

Location

Loc Qty

Loc Code

WA

17

67460

17

D3836-041

Manufactured No

100 Each

3.0000

1

D3836-041

Rib Assembly (Basket Lid, LH)

**

Pl 11.12.19

Location

Loc Qty

Loc Code

WA

2

72412

2

WA005

1

71746

1

D3836-042

Manufactured No

100 Each

3.0000

1

1

D3836-042

Rib Assembly (Basket Lid, RH)

**

Pl 11.12.19

Location

Loc Qty

Loc Code

WA

2

72413

2

WA005

1

71745

1

D3852-041

Manufactured No

100 Each

3.0000

1

1

D3852-041

Rib Assembly

**

Pl 11.12.19

Location

Loc Qty

Loc Code

WA

3

70722

3

Pl 11.12.19

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Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3852-042

Manufactured No

100

Each

4.0000

1

1

✓ *D3852-042*

Rib Assembly

**

PC 11.12.19

Location

Loc Qty

Loc Code

WA

4

66089

1

70723

3

①

November-11-11 9:23:17 AM

Shop Packet Print

Page 4

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

STRICTLY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO - 76383 M.L.J
11/11/11

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/11 M.L.J

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (2N D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

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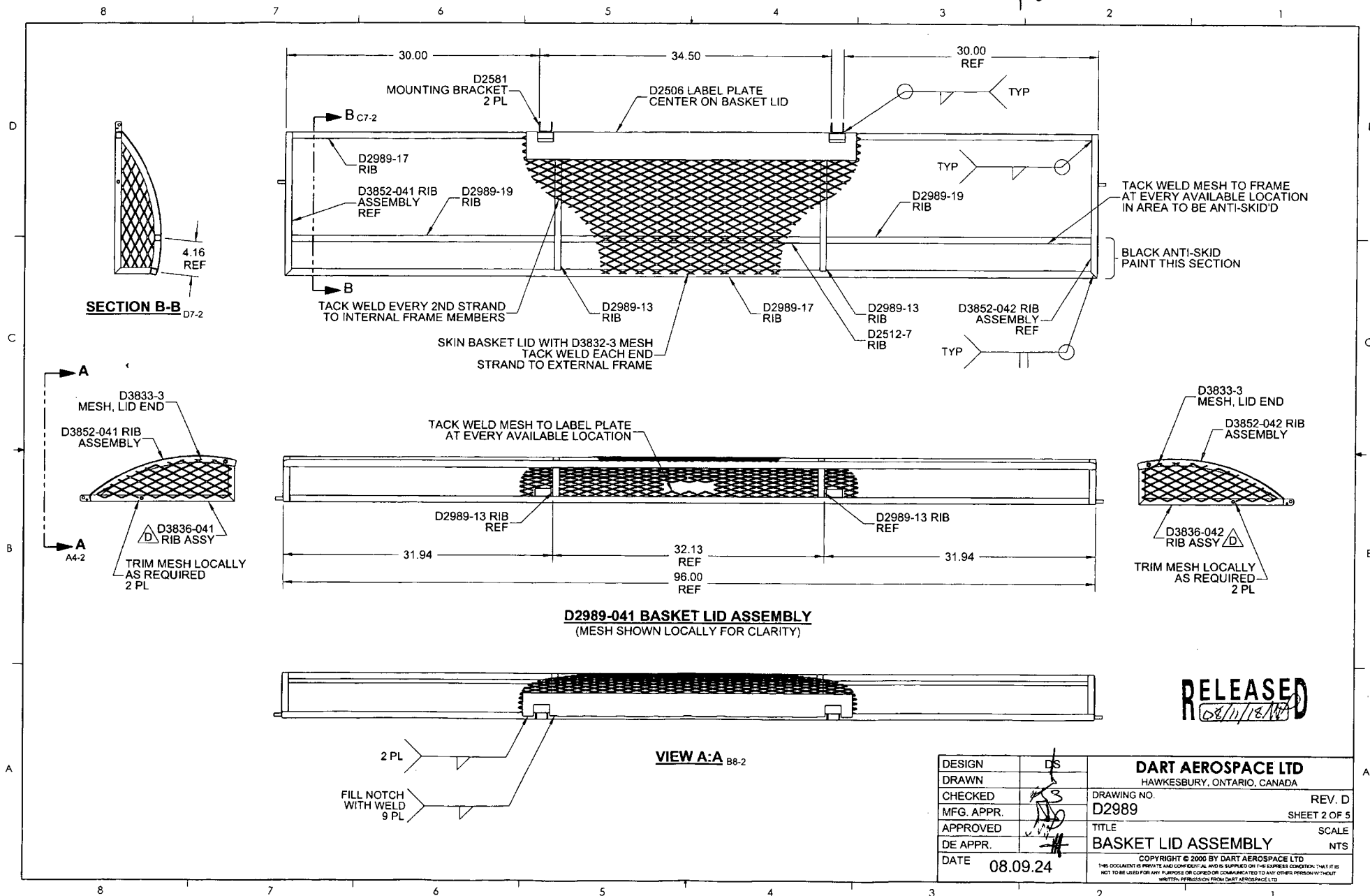
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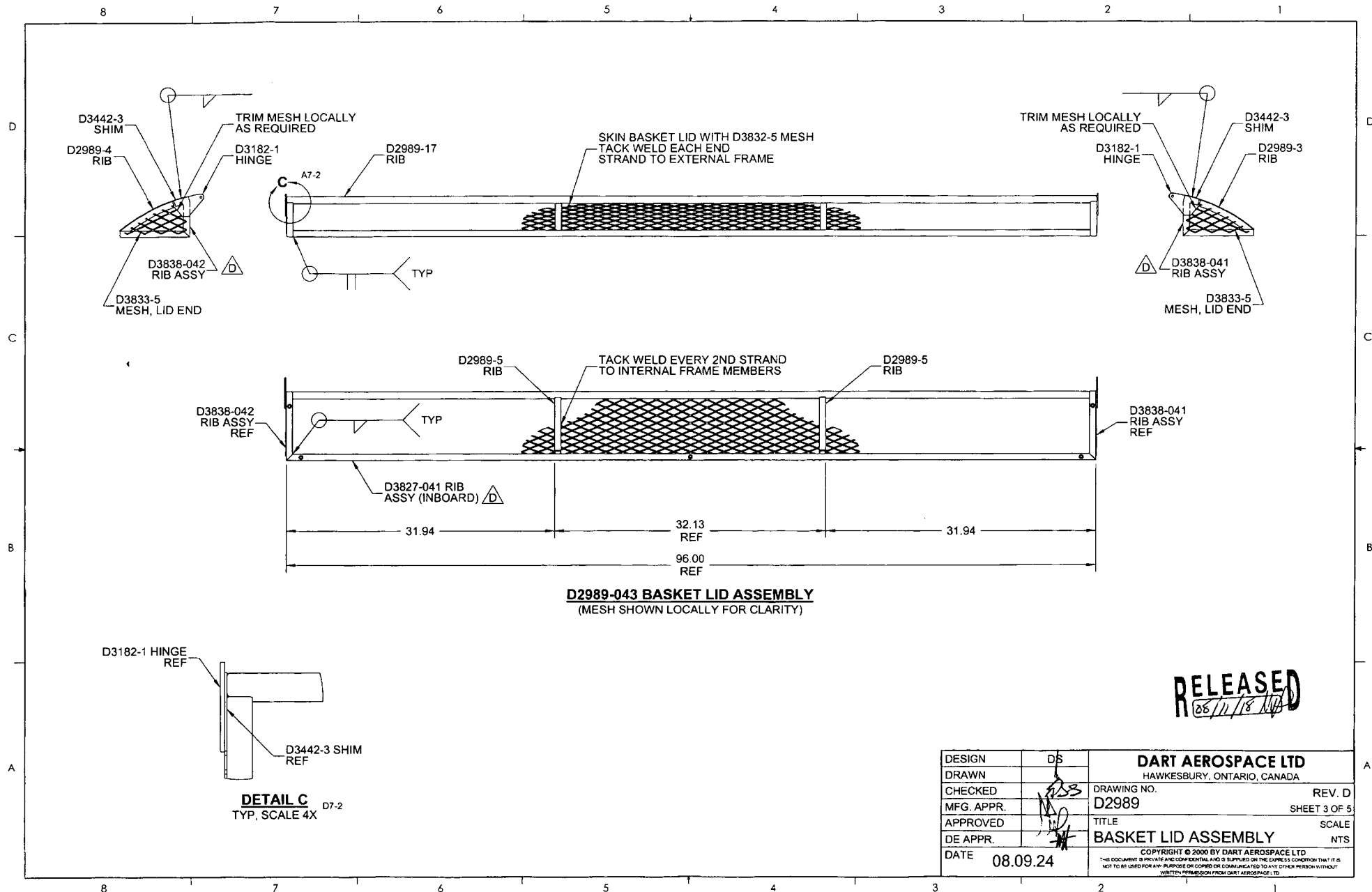
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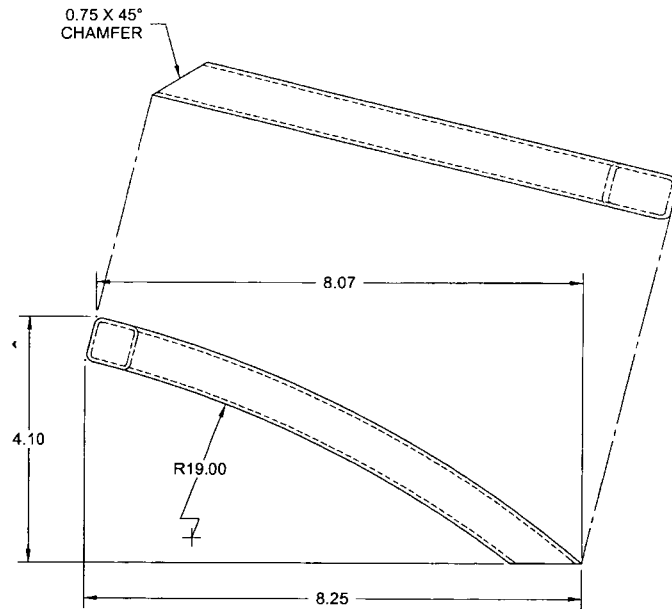
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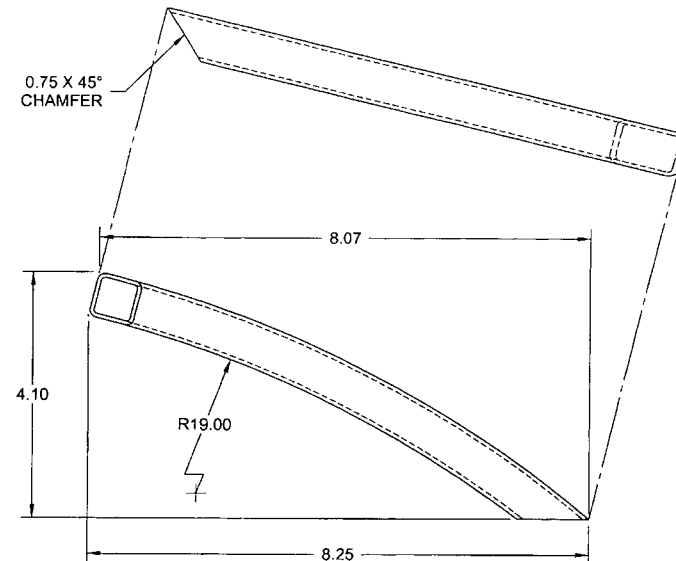
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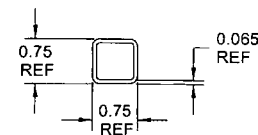
76383



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION VIEW

- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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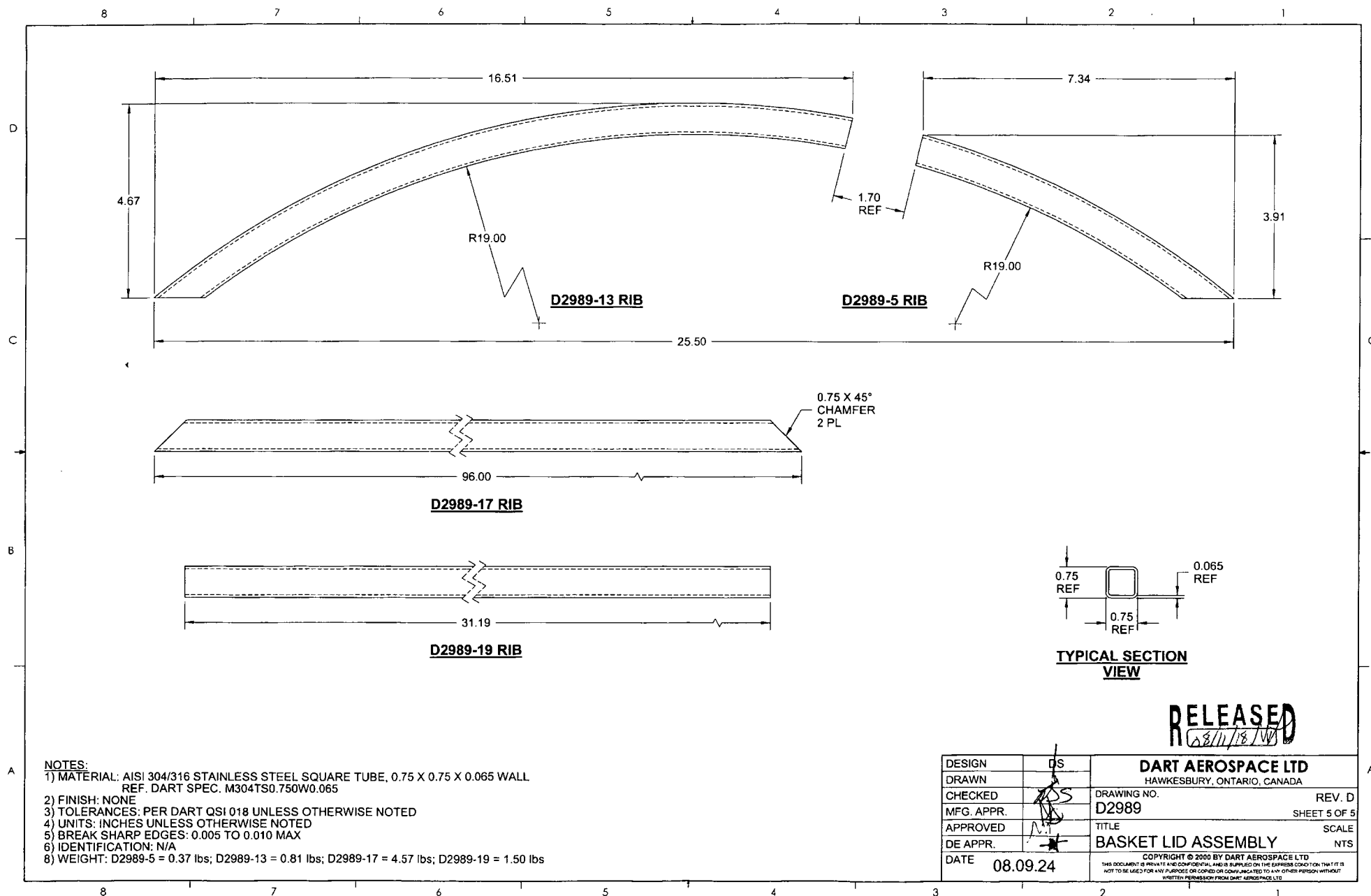
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08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO. D2989	REV. D
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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